

Work Order ID 76140

76140

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Monday, November 07, 2011 11:12:48 AM

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 11/7/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: 11-11-07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2739	Rev E

100 0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

- 1-Cut D2600-5 to length as per Dwg D2739.
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Deburr

0.00

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Hand Finishing

Memo

0.00

x7 _____ *1* _____ *OK*
u/11/16
PTQ →

x6 _____ *OK*
u/11/16

W/O: 76140		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2739 PAR #: N/A Fault Category: Dist. Tube NCR: Yes No DQA: OK Date: 11/11/29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/11/30

NCR: 11-1003		WORK ORDER NON-CONFORMANCE (NCR) \$ 62.90						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/16	100	Outermost hole in Detail A was drilled @ 1.0" should be 0.75"	CP 11/11/16 Q51042	Highest stress part of beam. Distance between holes too small. Approx. 50% increase in stress SCRAP + Replace Qty 1 B# 73909	Sh 11/11/16	Sh 11-11-16	CP 11.11.16 Q51042	
		Root Cause: TOOLING						

NOTE: Date & initial all entries

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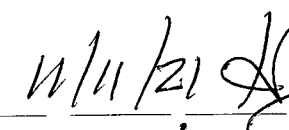
Monday, November 07, 2011 11:12:49 AM

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam

Start Date: 11/7/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00					<u>11-11-17</u>		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>46</u> Memo	0.00 0.00					<u>11-11-17</u>	<u>(6)</u>	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<u>11/11/21</u>		

11-11-18
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 07, 2011 11:12:53 AM

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Work Order ID: 76140

76140

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: C02.11.28ReformatKJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F
10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	268.0000	1	6			

D2600-5-108

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

LG

268

47814

20

73909

248

u/a/15

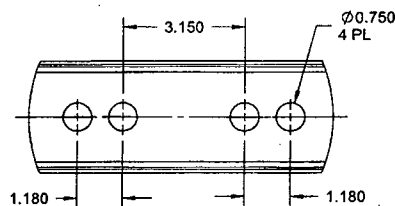
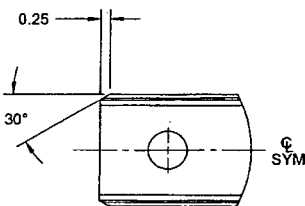
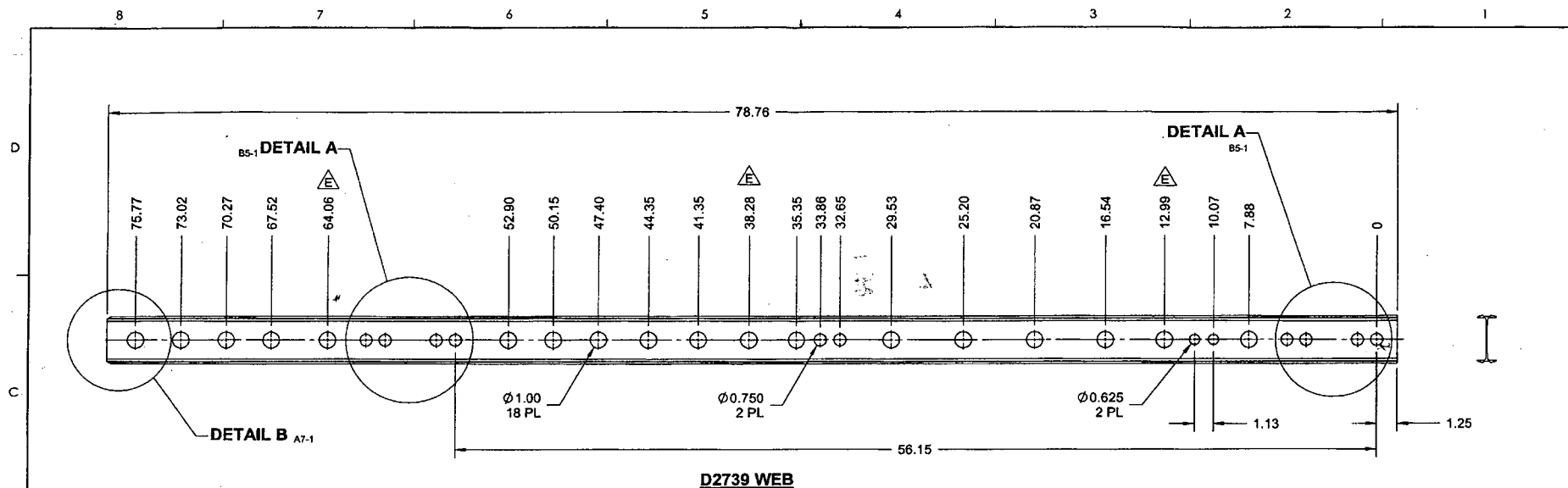
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2010-11-01

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT THE
WORK ORDER
NO. 76140

E	ADD/MOVE HOLES FOR D4154 WEARPLATE. 38.28 WAS 38.35 (DS-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, VA	
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D2739	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries